Work Order ID 93844

November-27-12 11:50:10 AM

93844

Item ID: D2661-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Saddle, RH Fwd Aft Out 206 **Stop** *NS2*

Start Date: 11/21/12 **Start Qty:** 22.00 *22*

Required Date: 12/14/12 **Req'd Qty:** 22.00 *22*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 12-11-28 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2661	Rev E								
100	HAAS CNC VERTICAL MACHINING #1	0.00			PD JL 12/12/21	22	Ø		
100									
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program part number and batch number MACHINE AS PER DWG AND FOLIO FB071 FOLIO REV: AA DWG REV: E								
110	CONVENTIONAL MILLING MACHINE	0.00			PD 12/12/29	22	Ø		JL
110									
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Item ID: D2661-2 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle, RH Fwd Aft Out 206
Start Date: 11/21/12 **Start Qty:** 22.00 *22* **Cust Item ID:**
Required Date: 12/14/12 **Req'd Qty:** 22.00 *22* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00	PO 12/12/29			22	Ø		
	Memo	0.00							
130 *130* QC Quality Control	QC8- Inspect parts - second check	0.00	b.a 12/12/29			22	ϕ		DAS 08 9-89
	Memo	0.00							
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				22	76	13-1-3	
	Memo	0.00							

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Turning Sequence
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- ☐ BOM/Route
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- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
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- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Item ID: D2661-2 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 11/21/12 **Start Qty:** 22.00 *22*
Required Date: 12/14/12 **Req'd Qty:** 22.00 *22*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum 1112338S.	0.00				22	ϕ	BL 12-1-7	
	Memo START TIME: 12:55 OVEN TEMPERATURE: 390° FINISH TIME: 1:25	0.00							
160 *160* QC Quality Control	QC3- Inspect Part Finish	0.00				22	ϕ	ML 12/6/07	
	Memo	0.00							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location 5L 432	0.00				22			SP 12-01-08
	Memo	0.00							

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

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- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

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_____

Item ID: D2661-2 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 11/21/12 **Start Qty:** 22.00 *22*
Required Date: 12/14/12 **Req'd Qty:** 22.00 *22*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180						MLJ	13-01-08		
QC	**Memo**	0.00							
Quality Control									

MF 13-01-08

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Picklist Print

November-27-12 11:50:09 AM

1

Work Order ID: 93844

Parent Item: D2661-2 **Start Date:** 11/21/12 **Required Date:** 12/14/12

Parent Item Name: Saddle, RH Fwd Aft Out 206 **Start Qty:** 22.00 **Required Qty:** 22.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
IPP REV:D REDESIGN PER ENG
ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 Saddle Billet, 7075		Manufactured	No			100	Each	140.0000	1	22			

Location	Loc Qty	Loc Code	
MAT040	79		
73775	2		
73780	7		
78599	10		
80765	0		
91239	60		
MAT042	60		
91238	30		
92531	30		
MAT044	1		
73769	1		

93319

22 FK 12/12/18

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
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☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
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☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

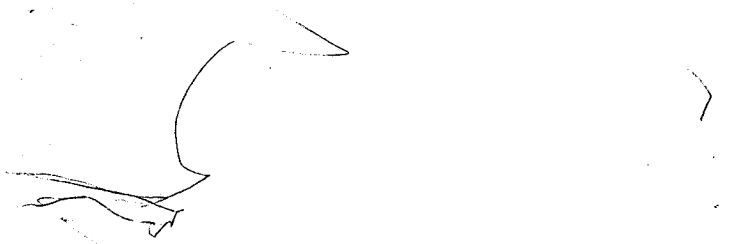
DART AEROSPACE LTD	Work Order:	93844
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	21	22	3	4	5
A	3.611	3.621		3.6166	3.616			
B	0.256	0.263		.258	.258			
C	0.315	0.322		.316	.316			
D	2.495	2.505		2.500	2.500			
E	1.674	1.684		1.679	1.679			
F	1.357	1.367		1.362	1.362			
G	0.100	0.140		.126	.125			
H	0.210	0.230		.224	.225			
I	0.615	0.685		.685	.685			
J	2.470	2.510		2.490	2.490			
K	1.313	1.343		1.327	1.326			
L	0.178	0.198		.188	.188			
M	0.470	0.530		.500	.500			
N	1.125	1.145		1.136	1.138			
O	0.100	0.180		.130	.130			
P	0.100	0.140		.112	.112			
Q	0.240	0.260		.248	.248			
R	0.677	0.697		.682	.683			
S	0.100	0.140		.119	.118			
T	1.565	1.585		1.576	1.579			
U	0.540	0.560		.551	.551			
V	0.912	0.932		.923	.923			
W	0.787	0.807		.795	.791			
X	5.990	6.010		6.000	6.000			
Y	4.995	5.005		5.000	5.000			
Z	0.490	0.510		.497	.496			
AA	0.312	0.319		.314	.314			
AB	0.990	1.010		1.000	1.000			
AC	1.245	1.255		1.250	1.250			
AD	0.490	0.510		.499	.499			
AE	3.745	3.755		3.750	3.750			
AF	0.235	0.240		.237	.237			
AG	0.510	0.515		.512	.512			
AH	0.100	0.120		.112	.112			
			Accept/Reject					

Measured by:	PO	**Date:**	12/12/29
Audited by:	D.A DAS 08 9-09	**Date:**	12/12/29
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	



DART AEROSPACE LTD	Work Order:	93844
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.126	.124	.124	.123	.123
H	0.210	0.230		.230	.225	.225	.225	.225
I	0.615	0.685		.675	.685	.685	.685	.685
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.333	1.327	1.327	1.327	1.328
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.137	1.135	1.137	1.135	1.135
O	0.100	0.180		.130	.130	.130	.130	.130
P	0.100	0.140		.118	.116	.117	.118	.117
Q	0.240	0.260		.255	.249	.250	.250	.251
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.125	.120	.124	.125	.124
T	1.565	1.585		1.577	1.575	1.577	1.575	1.575
U	0.540	0.560		.550	.551	.551	.551	.550
V	0.912	0.932		.920	.920	.922	.922	.922
W	0.787	0.807		.796	.796	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.499	.492	.500	.503	.504
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.001	1.001	1.001	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.503	.503	.503	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.103	.113	.113	.112	.112
			Accept/Reject					

Measured by:	SL	**Date:**	12-12-22
Audited by:		**Date:**	12/12/22
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD	Work Order:	93844
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	#9	#10
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.123	.122	.123	.123	.125
H	0.210	0.230		.225	.223	.225	.224	.227
I	0.615	0.685		.685	.685	.685	.685	.685
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.327	1.326	1.327	1.326	1.328
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	500	.500	.500
N	1.125	1.145		1.135	1.135	1.135	1.135	1.135
O	0.100	0.180		.130	.130	.130	130	.130
P	0.100	0.140		.118	.118	.117	.118	.114
Q	0.240	0.260		.251	.251	.250	.249	.248
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.124	.124	.124	.124	.123
T	1.565	1.585		1.575	1.575	1.575	1.575	1.575
U	0.540	0.560		.551	.550	.551	.551	.551
V	0.912	0.932		.922	.922	.922	.922	.922
W	0.787	0.807		.797	.797	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.505	.500	.500	.500	.500
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	.999	1.000	1.000	.999
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.499	.500	.500	.499
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.237	.112	.112	.112	.112
			Accept/Reject					

Measured by:	SL	**Date:**	10-12-22
Audited by:	D.A.S. 08 9-89	**Date:**	12/12/22 D.A.S. 08 9-89
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD	Work Order:	93844
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.124	.125	.123	.124	.124
H	0.210	0.230		.225	.226	.225	.225	.225
I	0.615	0.685		.685	.685	.685	.685	.685
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.328	1.328	1.327	1.327	1.327
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.135	1.135	1.135	1.135	1.136
O	0.100	0.180		.130	.130	.130	.130	.130
P	0.100	0.140		.117	.117	.116	.117	.116
Q	0.240	0.260		.248	.247	.249	.248	.248
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.122	.122	.123	.123	.123
T	1.565	1.585		1.575	1.575	1.575	1.575	1.576
U	0.540	0.560		.551	.551	.551	.551	.551
V	0.912	0.932		.922	.922	.922	.922	.922
W	0.787	0.807		.797	.797	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.500	.500	.500	.499
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.112
			Accept/Reject					

Measured by:		**Date:**	12-12-23
Audited by:	D.A	**Date:**	12/12/23
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD	Work Order:	93844
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.124	.124	.126	.126	.127
H	0.210	0.230		.225	.225	.227	.223	.226
I	0.615	0.685		.685	.685	.685	.685	.685
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.327	1.327	1.328	1.327	1.326
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.135	1.136	1.137	1.137	1.137
O	0.100	0.180		.130	.130	.130	.130	.130
P	0.100	0.140		.118	.117	.116	.112	.112
Q	0.240	0.260		.250	.249	.248	.245	.246
R	0.677	0.697		.687	.687	.687	.681	.685
S	0.100	0.140		.123	.122	.121	.115	.117
T	1.565	1.585		1.575	1.576	1.577	1.578	1.578
U	0.540	0.560		.551	.550	.551	.550	.551
V	0.912	0.932		.922	.922	.922	.924	.922
W	0.787	0.807		.797	.797	.797	.791	.792
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.006	5.000	5.000	5.000
Z	0.490	0.510		.500	.498	.495	.497	.499
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.499	.499	.497	.499
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.111
			Accept/Reject					

Measured by:	JL / RD	**Date:**	12-12-24
Audited by:	J.A	**Date:**	12/12/24
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

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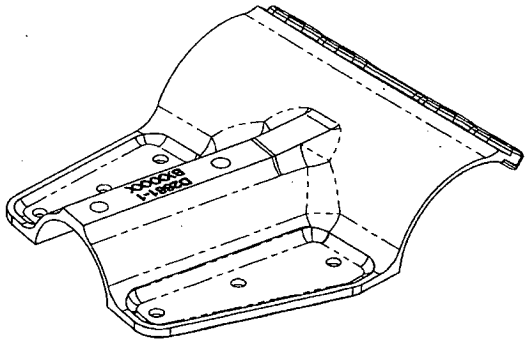
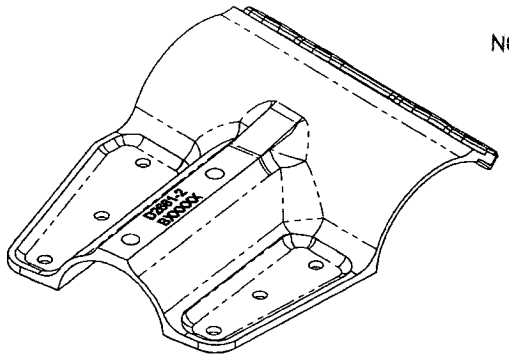
NO. 93844 MCS
12-11-28



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

RELEASED
2011-11-16

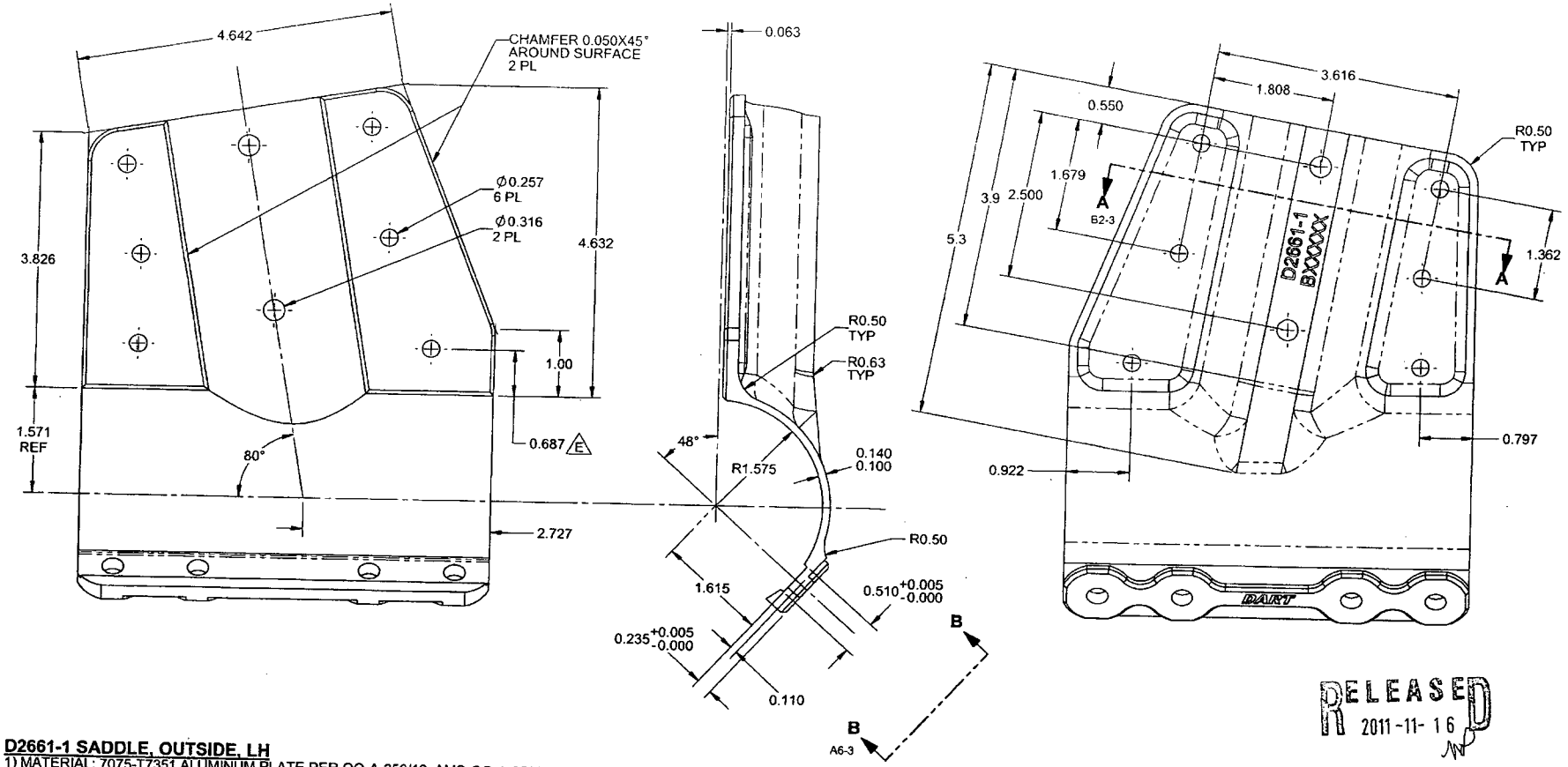
REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	11.10.31

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. D2661 REV. E
SHEET 1 OF 5
TITLE SADDLE, OUTSIDE SCALE NTS

93844



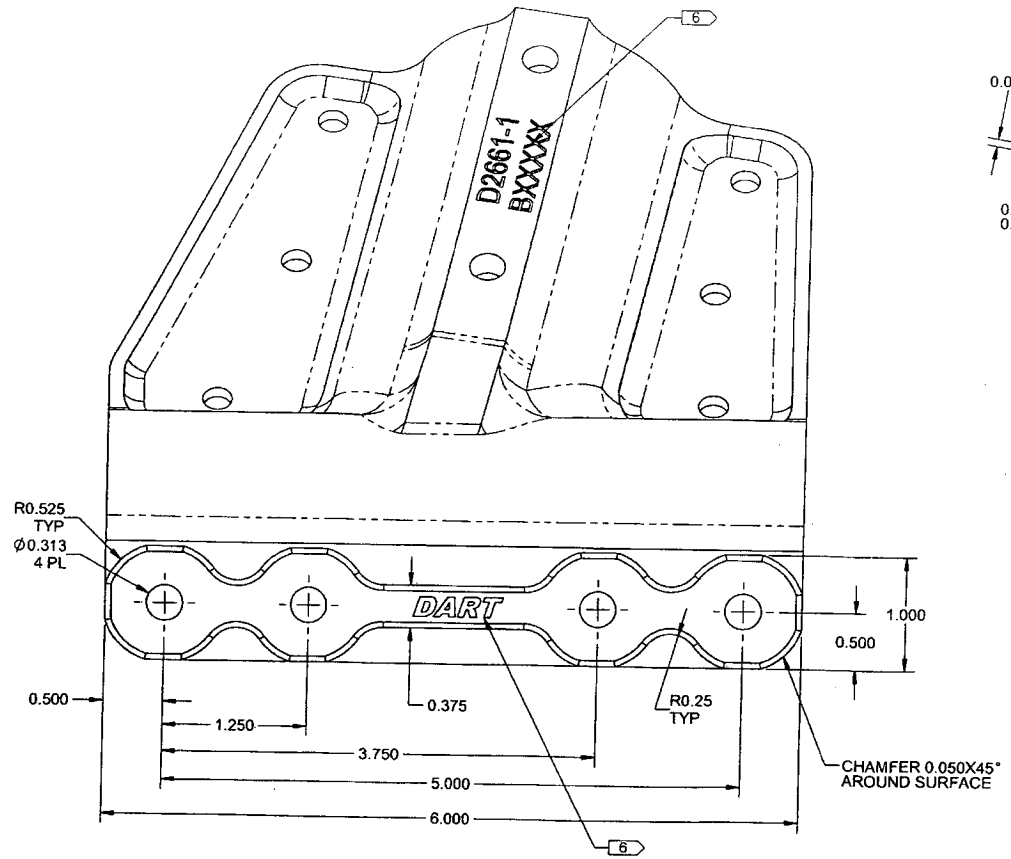
RELEASED
2011-11-16

D2661-1 SADDLE, OUTSIDE, LH

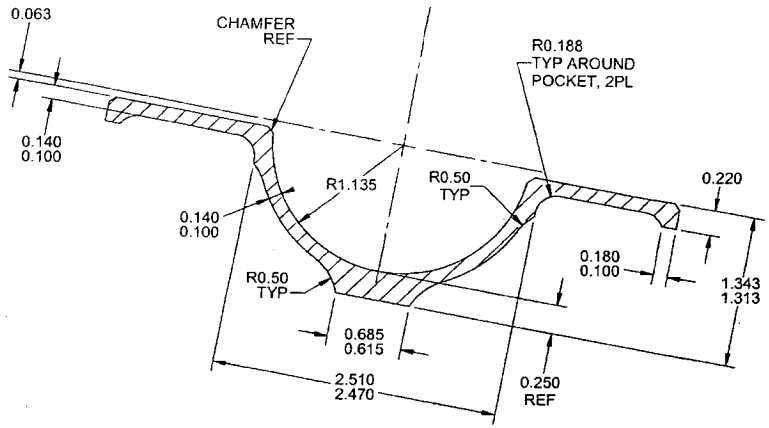
1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		DRAWING NO. D2661 REV. E
CHECKED	ASS	SHEET 2 OF 5
MFG. APPR.		TITLE SADDLE, OUTSIDE SCALE NTS
APPROVED		
DE APPR.		
DATE	11.10.31	

93244



VIEW B-B
SCALE 1.5X A4-2
VIEW ROTATED

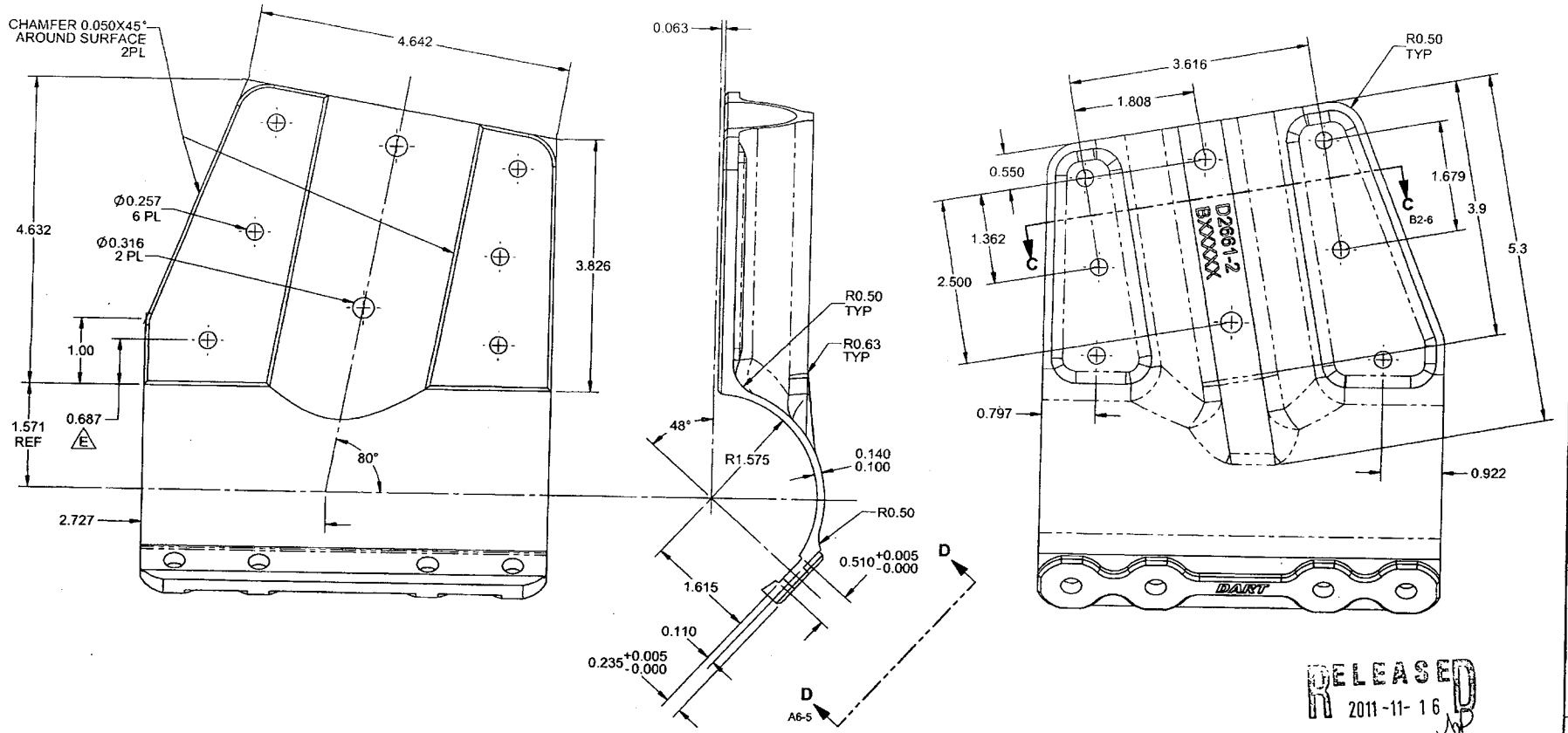


VIEW A-A
SCALE 1.5X C3-2

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2661 REV. E
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE SADDLE, OUTSIDE SCALE NTS
DE APPR.		
DATE 11.10.31		

93844



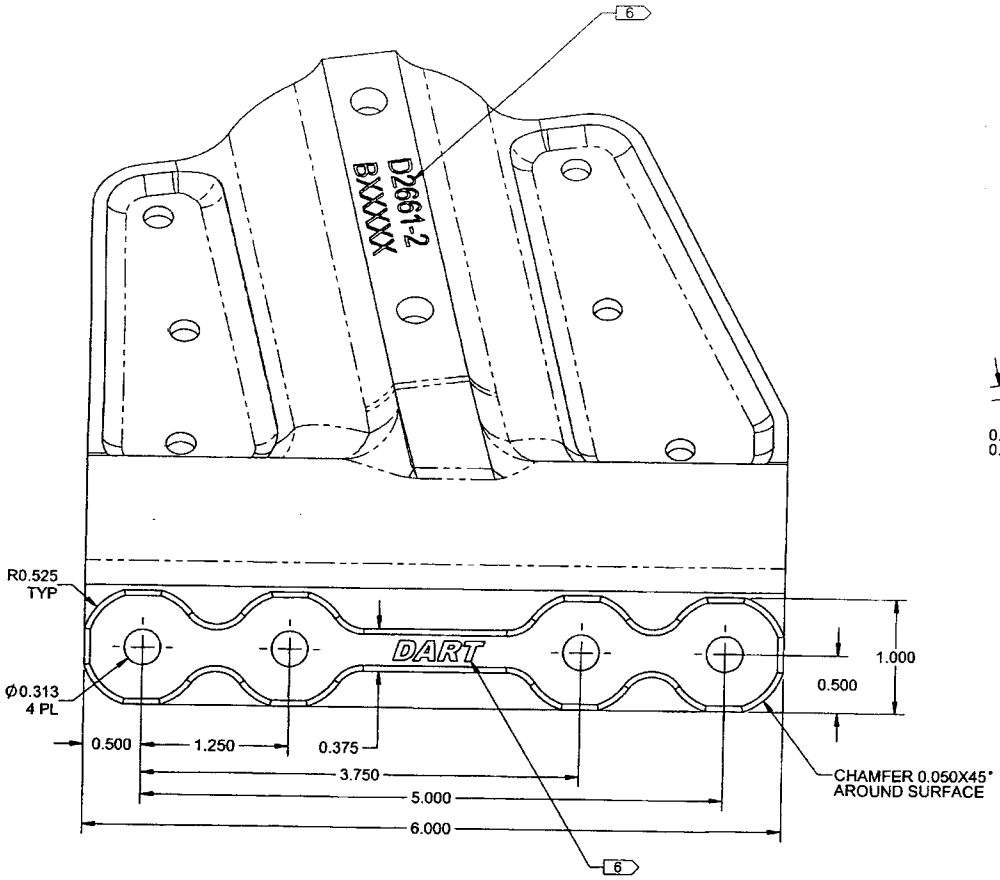
RELEASED
2011-11-16

D2661-2 SADDLE, OUTSIDE, RH

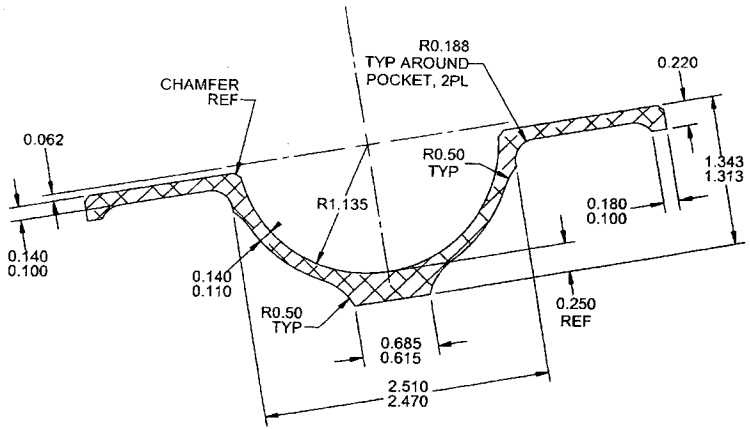
1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED	ASS	DRAWING NO. D2661 REV. E
MFG. APPR.		SHEET 4 OF 5
APPROVED		TITLE SADDLE, OUTSIDE SCALE NTS
DE APPR.		
DATE 11.10.31		

93844



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2661 REV. E
MFG. APPR.		SHEET 5 OF 5
APPROVED		TITLE SADDLE, OUTSIDE SCALE NTS
DE APPR.		
DATE 11.10.31		